

Work Order ID 73404



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Wednesday, August 31, 2011 3:05:50 PM

Item ID:	D3067-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	End Plate					
Start Date:	8/31/2011	Start Qty:	100.00		Cust Item ID:	
Required Date:	9/9/2011	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/08/31</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3067	Rev A								

100		FLOW WATER JET	0.00						
Waterjet		Memo	0.00					<u>B11-9-14</u>	
FLOW CNC Waterjet		1-Cut as per Dwg D3067							
<u>5052 . 063</u>		Dwg Rev: <u>A</u>							
		Prog Rev: <u>A</u>							
		2-Deburr if necessary							
110		QC2- Inspect parts off machine FAI/FAIB	0.00						
QC		Memo	0.00					<u>B11-9-14</u>	
Quality Control									
120		QC8- Inspect parts - second check	0.00						
QC		Memo	0.00						
Quality Control									

5 ulor 15

ccento
KJO

150

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73404



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Revision ID:				Stop	
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Start Date: 8/31/2011	Start Qty: 100.00		Cust Item ID:		
Required Date: 9/9/2011	Req'd Qty: 100.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg D3067	0.00 0.00		SB 11/09/15		(150)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sul 11/09/15		Count (150)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo *** STOCK IN STEP CELL***	0.00 0.00		11.09.15		150			

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Item ID: D3067-1

Accept



Setup Start



Revision ID:

Stop



Item Name: End Plate

Start Date: 8/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/16

MF

11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73404



Parent Item: D3067-1



Parent Item Name: End Plate


Start Date: 8/31/2011

Required Date: 9/9/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: ☐ 03.01.21 Remove step 6 (Deburr) KJ ☐
IPP Rev:B Now on Water jet 06-06-16 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased		No		100	sf	77.5000	0.0625	6.578947	9.5		
													

5052-H32 .063 Sheet



B11-9-14

Location

Loc Qty

Loc Code

MAT022

77.5

114322

77.5

114322

150

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

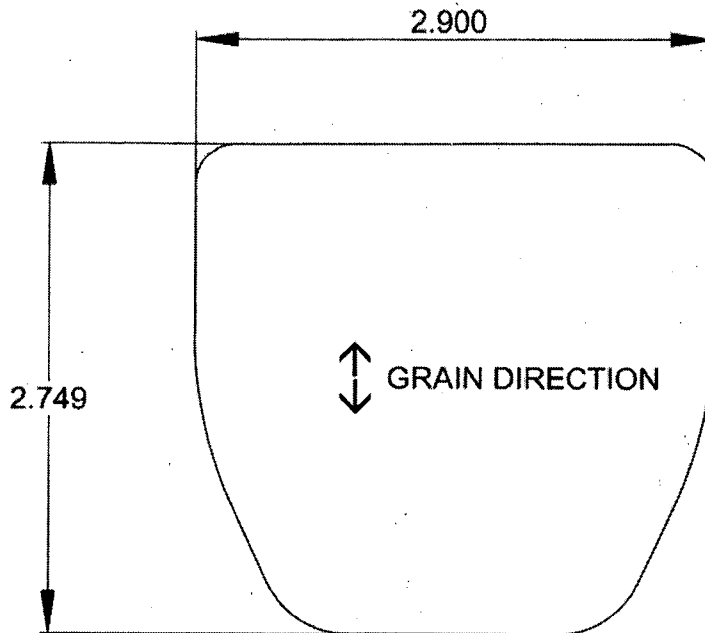
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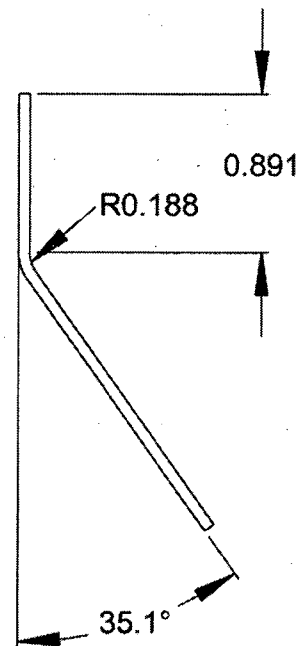


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73404
CL11/08/31

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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